

Claims.

1. Butt-joining method comprising:
In two abutting metal strips punching a substantially rectangular slot into both abutments,
inserting into said two slots a deformable slug, clinching it into said slots,
5 thereby securely joining said strips.
2. Butt-joining method as defined in claim 1 wherein said slots in both said abutments
are keystone shaped instead of rectangular.
3. Butt-joining method as defined in claim 1 wherein said slots in both said abutments
have two rounded edges produced by both a punch and a die.
- 10 4. Butt-joining method as defined in claim 1 wherein said strips are of other material than metal.
5. Butt-joining method as defined in claim 1 wherein a plurality of slots are used.
6. Butt-joining method as defined in claim 2 wherein said keystone shaped slugs
are also having said rounded corners.
7. Butt-joining clinch method comprising:
15 In two abutting metal strips punching a substantially rectangular slot into both abutments,
using one knock-out-slug from said punching, re-inserting said slug into the center
of said abutment, clinching it into said slots thereby securely joining said strips.
8. Butt-joining clinch method as defined in claim 7 wherein said slots in both said abutments
is keystone shaped instead of rectangular.
- 20 9. Butt-joining clinch method as defined in claim 7 wherein said slots in both said abutments
have two rounded edges produced by both a punch and a die.
10. Butt-joining clinch method as defined in claim 7 wherein said strips
are of other material than metal.
11. Butt-joining clinch method as defined in claim 7 wherein a plurality of slots is used.
- 25 12. Butt-joining clinch method as defined in claim 7 wherein said clinching height
is flush or slightly below the surface of said strip.